

Work Order ID 150823

Thursday, September 08, 2016 8:32:55 AM

150823

AMOD
DG

Page 1

Item ID: D412-630-032DG

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Pilot/Co-Pilot Folding Step RH - Low, High & Float Gear, Drab Green

Start Date: 9/30/2016 Start Qty: 4.00 ***4***

Cust Item ID:

Required Date: 10/31/2016 Req'd Qty: 4.00 ***4***

Customer:

Reference:

Approvals: Process Plan: **DAS 21 9-89** Date: **SEP 08 2016** Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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IIN D412-630	O
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DAS 6 9-89

DAS 21 9-89

1610-11
4

100 Document Control
DOCUMENT CONTROL

0.00 **OCT 07 2016**

100

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy D412-630 bluefile & type labels per PPP412-630-032 CHG004

DAS 27 9-89

OCT 17 2016

110

0.00

110

Small Fab

Small Fab

Memo

0.16

Small Fab

Assemble as per IIN D412-630

****ensure tension to retract step is 11 to 18 lbs before installing lockwire.****

A/R MS20995C41 batch: **131371**

DAS 36 9-89

16/10/19

4x

[Handwritten signature]

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
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								Lead hand / Supervisor Approval Verification																	
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Root Cause		FAULT CATEGORY																							
Environment ☐		No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐																			
Design ☐		Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐																			
Doc/Data ☐		Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐																			
Equip/Tooling ☐		Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐																			
Handling/Pre ☐		Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐																			
Material ☐		Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐																			
Internal Transport ☐		Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐																			
Tribal Knowledge ☐		Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐																			
LOA ☐		Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐																			
Substation ☐		Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐																			
Past Expiry Date ☐		Manufacturing Process ☐	OTHER : _____																						
Misidentified ☐		Past Due ☐																							

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Page 2

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Revision ID: Stop ***NS2***
Item Name: Pilot/Co-Pilot Folding Step RH - Low, High & Float Gear, Drab Green
Start Date: 9/30/2016 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 10/31/2016 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo ***ensure tension to retract step is 11 to 18 lbs *** Test fit on aircraft in Eng. lab. ENSURE STEP IS A <u>RH</u>	0.00 0.01				4			DAS 28 9-89 OCT 10 2016 9 9-89 16-10-19
130 *130* Packaging Packaging	Pick Kit Memo	0.00 0.00				4			OCT 11 2016 DAS 28 6 9-89
140 *140* QC Quality Control	QC4- 100% Inspect kits for completeness Memo	0.00 0.02							DAS 27 9-89 OCT 17 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Root Cause		FAULT CATEGORY							
Environment ☐	☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐			
Design ☐	☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐			
Doc/Data ☐	☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐			
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Handling/Pre ☐	☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐			
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150		0.00							
150	Packaging								
Packaging	Memo	0.00		X4	DAS 28 9-89				
Packaging	Identify and pack for shipping as per PPP D412-630-032 ENSURE STEP IS A RH: _____ Location;FG034 Sold				DAS 27 9-89				
					OCT 1 9 2016				
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.07				DAS 21 9-89			OCT 1 9 2016
Quality Control									

OCT 1 9 2016

DAS
21
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

Picklist Print

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Page 1

Work Order ID: 150823

150823

Parent Item: D412-630-032DG

D412-630-032DG

Parent Item Name: Pilot/Co-Pilot Folding Step RH - Low, High & Float Gear, Drab Green

Start Date: 9/30/2016

Required Date: 10/31/2016

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV. A 05.11.21 NEW ISSUE EC
 IPP REV. B 05.12.19 updated pick list EC
 IPP REV. C 07.11.12 ecn 1019, nochg EC verified by: DD IPP Rev: D
 10.05.28 added route seq DD verf: EC IPP Rev: E 11.06.01
 removed qty 1 an310-4 EC verified by: DD IPP REV: F 16.06.23 AS PER
 IIN REV. O DD VERF: JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN310-4		Purchased	No			110	Each	169.0000	1	4			
AN310-4									**			OCT 11 2016	DAS 6 9-89
Nut													

Location	Loc Qty	Loc Code
GA	25	
M127815	25	
OVER007	100	
M135442	100	
ST331	44	
M134955	44	

AN310-7		Purchased	No			110	Each	65.0000	1	4			
AN310-7									**			OCT 11 2016	DAS 6 9-89
Nut													

Location	Loc Qty	Loc Code
ST331	65	
124198	25	
m120124	40	

AN4C14		Purchased	No			110	Each	32.0000	1	4			
AN4C14									**			OCT 11 2016	DAS 6 9-89
Bolt													

Location	Loc Qty	Loc Code
ST344	32	
m131264	2	
m135084	30	

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Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐																
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Page 2

Work Order ID: 150823

150823

Parent Item: D412-630-032DG

D412-630-032DG

Parent Item Name: Pilot/Co-Pilot Folding Step RH - Low, High & Float Gear, Drab Green

Start Date: 9/30/2016

Required Date: 10/31/2016

Start Qty: 4.00

Required Qty: 4.00

AN4CH3 Purchased No 110 Each 83.0000 2 8

AN4CH3

Bolt

**

OCT 11 2016

DAS
9-89

Location Loc Qty Loc Code

ST346 83

M132124 8

M135482 75

D3443-041 Manufactured No

D3443-041

Strut Weldment Assembly

**

16/10/17

DAS
36
9-89

Location Loc Qty Loc Code

ST525 1

144279 1

D3443-043 Manufactured No

D3443-043

Strut Weldment Assembly

**

2x149329
2x149328

16/10/17 sub

DAS
6
9-89

Location Loc Qty Loc Code

ST525 1

145453 1

D3443-9 Manufactured No

D3443-9

Pin

**

OCT 11 2016

DAS
6
9-89

Location Loc Qty Loc Code

ST037 115

145541 14

149322 101

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Shop Packet Print

Page 2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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OTHER : _____																																																															

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Parent Item: D412-630-032DG

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Parent Item Name: Pilot/Co-Pilot Folding Step RH - Low, High & Float Gear, Drab Green

Start Date: 9/30/2016

Required Date: 10/31/2016

Start Qty: 4.00

Required Qty: 4.00

D3454-7 Manufactured No 110 Each 124.0000 2 8

D3454-7

Bushing

**

OCT 11 2016

DAS
6
9-89

Location Loc Qty Loc Code

ST037 22

144631 22

ST038A 102

149466 102

D3455-1 Manufactured No 110 Each 373.0000 2 8

D3455-1

Spacer

**

OCT 11 2016

DAS
6
9-89

Location Loc Qty Loc Code

ST037 66

147371 66

ST038A 307

149364 307

D3463-042 Manufactured No 110 Each 2.0000 1 4

D3463-042

Step Weldment Assembly

**

DAS
36
9-89

~~OCT 11 2016~~

Location Loc Qty Loc Code

ST386 2

144282 2

D3465-1 Manufactured No 110 Each 96.0000 1 4

D3465-1

Washer

**

OCT 11 2016

DAS
6
9-89

Location Loc Qty Loc Code

ST038 96

148257 44

149356 52

DQA: _____ Date: _____



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Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

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Page 4

Work Order ID: 150823

150823

Parent Item: D412-630-032DG

D412-630-032DG

Parent Item Name: Pilot/Co-Pilot Folding Step RH - Low, High & Float Gear, Drab Green

Start Date: 9/30/2016

Required Date: 10/31/2016

Start Qty: 4.00

Required Qty: 4.00

MS24665-227

Purchased

No

110

Each

105.0000

1

4

MS24665-227

Cotter Pin

**

OCT 11 2016
DAS
6
9-89

Location

Loc Qty

Loc Code

GA

16

111041

16

ST289

89

m127831

89

MS24665-302

Purchased

No

110

Each

29.0000

1

4

MS24665-302

Cotter Pin

**

135612

OCT 11 2016
DAS
6
9-89

Location

Loc Qty

Loc Code

GA

15

120521

15

ST288

14

m134738

14

AN310-4

Purchased

No

130

Each

169.0000

1

4

AN310-4

Nut

**

OCT 12 2016
DAS
28
6
9-89

Location

Loc Qty

Loc Code

GA

25

M127815

25

OVER007

100

M135442

100

ST331

44

M134955

44

DAS
27
9-89

Thursday, September 08, 2016 8:32:58 AM

Shop Packet Print

Page 4

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

Picklist Print

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Page 5

Work Order ID: 150823

150823

Parent Item: D412-630-032DG

D412-630-032DG

Parent Item Name: Pilot/Co-Pilot Folding Step RH - Low, High & Float Gear, Drab Green

Start Date: 9/30/2016

Required Date: 10/31/2016

Start Qty: 4.00

Required Qty: 4.00

AN310-5 Purchased No 130 Each 25.0000 2 8

AN310-5

Nut

**

135672/

DAS 6 28
9-89 9-89

OCT 12 2016

Location Loc Qty Loc Code

ST331 25
m129706 9
m131320 16

DAS 27
9-89

AN3C5A Purchased No 130 Each 1,277.000 3 12

AN3C5A

Bolt

**

DAS 6 28
9-89 9-89

OCT 12 2016

Location Loc Qty Loc Code

FG 5
122800 5
FP001 199
M134955 174
M135470 25
OVER002 800
M135297 600
M135442 200
ST350 273
M133234 1
M134676 272

DAS 27
9-89

AN44-C12 Purchased No 130 Each 12.0000 1 4

AN44-C12

Eye Bolt

**

135704/

DAS 6 28
9-89 9-89

OCT 12 2016

Location Loc Qty Loc Code

FG 3
124829 3
ST339 9
M132879 4
M135297 5

DAS 27
9-89

Thursday, September 08, 2016 8:32:58 AM

Shop Packet Print

Page 5

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

Picklist Print

Page 6

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Work Order ID: 150823

150823

Parent Item: D412-630-032DG

D412-630-032DG

Parent Item Name: Pilot/Co-Pilot Folding Step RH - Low, High & Float Gear, Drab Green

Start Date: 9/30/2016

Required Date: 10/31/2016

Start Qty: 4.00

Required Qty: 4.00

AN4C15 Purchased No 130 Each 29.0000 1 4

AN4C15

Bolt

**

OCT 12 2016 **DAS 6 28**
9-89 9-89

Location Loc Qty Loc Code

OVER002 15

M135046 15

ST343 14

M1134567 14

AN5C11 Purchased No 130 Each 11.0000 1 4

AN5C11

BOLT

**

OCT 12 2016 **DAS 6 28**
9-89 9-89

Location Loc Qty Loc Code

ST338 11

M134887 11

AN5C15 Purchased No 130 Each 14.0000 1 4

AN5C15

BOLT

**

OCT 12 2016 **DAS 6 28**
9-89 9-89

Location Loc Qty Loc Code

ST337 14

M132317 4

M135297 10

D3454-1 Manufactured No 130 Each 58.0000 1 4

D3454-1

Bushing

**

OCT 12 2016 **DAS 6 28**
9-89 9-89

Location Loc Qty Loc Code

ST037 58

146027 10

149447 48

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Shop Packet Print

Page 6

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																						
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																						
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																						
Large Fab ☐	Composite ☐	Supplier ☐																							
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition				Completed By																	
								Lead hand / Supervisor Approval Verification																	
								QC / QA Coordinator Approval																	
Root Cause		FAULT CATEGORY																							
Environment ☐		No Re-verification ☐		Pressure/Forced ☐		Temperature/Cure ☐		Power Loss/Surge ☐		Positioned Wrong ☐															
Design ☐		Operator ☐		Bending ☐		Set-up ☐		Folio/Program ☐		Outside Dimensions ☐															
Doc/Data ☐		Offset/Setup ☐		Centre Not Concentric ☐		BOM/Route ☐		Grain ☐		Over/Under tolerance ☐															
Equip/Tooling ☐		Supplier ☐		Cracks ☐		Broken/Damage/Defect ☐		Weld ☐		Part Incorrect ☐															
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LOA ☐		Product Improvement ☐		Wave/Twist in Tube ☐		Instructions Incomplete/Unclear ☐		Fit/Function ☐		Misread ☐															
Substation ☐		Process Improvement ☐		Marks/Chatter ☐		Drill Holes ☐		Misaligned/off center ☐		Turning Sequence ☐															
Past Expiry Date ☐		Manufacturing Process ☐		OTHER : _____																					
Misidentified ☐		Past Due ☐																							

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Work Order ID: 150823

150823

Parent Item: D412-630-032DG

D412-630-032DG

Parent Item Name: Pilot/Co-Pilot Folding Step RH - Low, High & Float Gear, Drab Green

Start Date: 9/30/2016

Required Date: 10/31/2016

Start Qty: 4.00

Required Qty: 4.00

D3454-3

Manufactured No

130

Each

123.0000

2

8

D3454-3

Bushing

**

OCT 12 2016

DAS 18
6 9-89

DAS 27
9-89

Location

Loc Qty

Loc Code

ST037

123

121223

22

149416

101

D3454-5

Manufactured No

130

Each

117.0000

2

8

D3454-5

Bushing

**

OCT 12 2016

DAS 28
6 9-89

DAS 27
9-89

Location

Loc Qty

Loc Code

ST037

13

148239

13

ST038A

104

145571

3

149326

101

D3455-1

Manufactured No

130

Each

373.0000

4

16

D3455-1

Spacer

**

OCT 12 2016

DAS 28
6 9-89

DAS 27
9-89

Location

Loc Qty

Loc Code

ST037

66

147371

66

ST038A

307

149364

307

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																															
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Design ☐	Operator ☐																																																																						
Doc/Data ☐	Offset/Setup ☐																																																																						
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		OTHER : _____																																																																					

Picklist Print

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Page 8

Work Order ID: 150823

150823

Parent Item: D412-630-032DG

D412-630-032DG

Parent Item Name: Pilot/Co-Pilot Folding Step RH - Low, High & Float Gear, Drab Green

Start Date: 9/30/2016

Required Date: 10/31/2016

Start Qty: 4.00

Required Qty: 4.00

D3455-3

Manufactured No

130

Each

117.0000

2 8

D3455-3

Spacer

**

OCT 12 2016

DAS
28
69-89
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

ST037

95

146067

11

149459

84

ST038A

22

149312

22

D3462-042

Manufactured No

130

Each

2.0000

1 4

D3462-042

Bracket Assembly

**

149441

OCT 17 2016

OCT 12 2016

DAS
28
69-89

DAS
28
69-89

DAS
28
69-89

DAS
27
9-89

Location

Loc Qty

Loc Code

ST038

2

146512

2

D3672-5

Manufactured No

130

Each

622.0000

1 4

D3672-5

Washer, Phenolic

**

OCT 12 2016

DAS
28
69-89

DAS
27
9-89

Location

Loc Qty

Loc Code

FG

8

44679

8

ST049

234

35521

234

ST051A

380

50354

380

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																			
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Picklist Print

Thursday, September 08, 2016 8:32:58 AM

Work Order ID: 150823

150823

Parent Item: D412-630-032DG

D412-630-032DG

Parent Item Name: Pilot/Co-Pilot Folding Step RH - Low, High & Float Gear, Drab Green

Start Date: 9/30/2016

Required Date: 10/31/2016

Start Qty: 4.00

Required Qty: 4.00

MS21043-3

Purchased

No

130

Each

1,202.000

3

12

MS21043-3

Nut

**

OCT 12 2016

DAS
28
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

FG	80	
103691	80	
FP001	11	
m130673	11	
GA	235	
m133990	235	
ST302	807	
m135058	7	
<u>m135442</u>	400	12
m135544	400	
ST304	69	
m131340	69	

MS24665-227

Purchased

No

130

Each

105.0000

2

48

MS24665-227

Cotter Pin

**

OCT 12 2016

DAS
6
9-89

DAS
28
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

GA	16	
111041	16	
ST289	89	
<u>m127831</u>	89	8

QA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval 	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	

Root Cause			FAULT CATEGORY		
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐				

Picklist Print

Thursday, September 08, 2016 8:32:58 AM

Work Order ID: 150823

150823

Parent Item: D412-630-032DG

D412-630-032DG

Parent Item Name: Pilot/Co-Pilot Folding Step RH - Low, High & Float Gear, Drab Green

Start Date: 9/30/2016

Required Date: 10/31/2016

Start Qty: 4.00

Required Qty: 4.00

MS24665-229

Purchased

No

130

Each

71.0000

2

8

MS24665-229

Cotter Pin

**

OCT 12 2016

DAS 28
6 9-89

DAS 27
9-89

Location

Loc Qty

Loc Code

GA

5

118234

5

ST289

66

m132123

66

NAS1149C0363R

Purchased

No

130

Each

478.0000

7

28

NAS1149C0363R

Washer

**

135872

OCT 12 2016

DAS 28
6 9-89

DAS 27
9-89

Location

Loc Qty

Loc Code

FP001

265

114742

6

m133077

259

GA

213

m133077

213

NAS1149C0563R

Purchased

No

130

Each

422.0000

1

4

NAS1149C0563R

Washer

**

OCT 12 2016

DAS 28
6 9-89

DAS 27
9-89

Location

Loc Qty

Loc Code

ST265

422

m131697

422

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
								Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	

Root Cause				FAULT CATEGORY						
Environment ☐	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong
Design ☐	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions
Doc/Data ☐	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance
Equip/Tooling ☐	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect
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Material ☐	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved
Internal Transport ☐	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing
Tribal Knowledge ☐	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish
LOA ☐	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread
Substation ☐	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence
Past Expiry Date ☐	☐	Manufacturing Process								
Misidentified ☐	☐	Past Due								
			OTHER :							

Work Order ID 150821

Tuesday, October 11, 2016 1:18:06 PM

150821

Page 1

Item ID: D412-630-032DG

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Pilot/Co-Pilot Folding Step RH - Low, High & Float Gear, Drab Green

Start Date: 9/30/2016 Start Qty: 4.00

4

Cust Item ID:

Required Date: 10/31/2016 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

IIN D412-630

O

DAS
21
9-89

OCT 11 2016

0.00

100

Document Control

DOCUMENT CONTROL

100

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy D412-630 bluefile & type labels per PPP412-630-032 CHG004

110

0.00

110

Small Fab

Small Fab

Memo

0.16

Small Fab

Assemble as per IIN D412-630

****ensure tension to retract step is 11 to 18 lbs before installing lockwire.****

A/R MS20995C41 batch: _____

DAS
21
9-89

OCT 11 2016

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

Qty -031	Qty -032	Part Number	Description
X		D412-630-031	PILOT/CO-PILOT STEP, LH (FOLDING)
	X	D412-630-032	PILOT/CO-PILOT STEP, RH (FOLDING)
1	1	D3443-041	STRUT ASSEMBLY
1	1	D3443-043	STRUT ASSEMBLY
2	2	D3443-9	PIN
1	1	D3454-1	BUSHING
2	2	D3454-3	BUSHING
2	2	D3454-5	BUSHING
2	2	D3454-7	BUSHING
6	6	D3455-1	SPACER
2	2	D3455-3	SPACER
1		D3462-041	BRACKET ASSEMBLY
	1	D3462-042	BRACKET ASSEMBLY
1		D3463-041	STEP ASSEMBLY
	1	D3463-042	STEP ASSEMBLY
1	1	D3465-1	WASHER
1	1	D3672-5	WASHER (OR NAS1515H5)
2	2	AN310-4	NUT
2	2	AN310-5	NUT
1	1	AN310-7	NUT
2	2	AN3C5A	BOLT
1	1	AN3C6A	BOLT
1	1	AN44-C12	* EYEBOLT
1	1	AN4C14	BOLT
1	1	AN4C15	BOLT
2	2	AN4CH3	BOLT
1	1	AN5C11	BOLT
1	1	AN5C15	BOLT
7	7	NAS1149C0363R	WASHER (OR AN960C10)
1	1	NAS1149C0563R	WASHER (OR AN960C516)
3	3	MS21043-3	NUT
2	2	MS24665-227	COTTER PIN
2	2	MS24665-229	COTTER PIN
1	1	MS24665-302	COTTER PIN

* USE AN44-C12 EYEBOLT WHEN D412-630-031/-032 IS INSTALLED IN CONJUNCTION WITH D412-630-023/-024/-033/-034™ HELI-ACCESS-STEP.
SEE FIGURE 13B (D412-630-023/-024 KITS) OR FIGURE 16B (D412-630-033/-034 KITS).